Work Order ID 63326

Wednesday, October 27, 2010 3:02:28 PM

Item ID: D2876 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Saddle Spacer

Start Date: 10/27/2010 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 11/11/2010 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** H **Date:** 10-10-27 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2876	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00				HB10-11-1			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D 2876 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary					47			
110	QC2- Inspect parts off machine FAI/FAIB	0.00				HB10-11-1			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				counted x47			
QC	**Memo**	0.00 10/11/01							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab	0.00							
	Memo Remove tabs and Tumble	0.00				n/h 8			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				47	0		
	Memo	0.00							
150 QC Quality Control	QC3- Inspect Part Finish	0.00				47	BR 10-11-2		
	Memo	0.00							

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Start Date: 10/27/2010 **Start Qty:** 40.00

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: Q26	0.00							
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/11/2 47

10/11/03

YMF

10-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 3:02:32 PM

Work Order ID: 63326

Parent Item: D2876

Parent Item Name: Saddle Spacer

Start Date: 10/27/2010 **Required Date:** 11/11/2010

Start Qty: 40.00 **Required Qty:** 40.00

Comments: Esr Rev:B□00.05.19□Added inspect level 8□EC
IPP Rev:C Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100		Purchased	No			100	sf	66.1488	0.0516	2.172632			
6061-T6 .100 Sheet													

Location		Loc Qty	Loc Code
MAT21		31.67	
	102201	31.67	
MAT5		34.47877902	
	102201	34.4787790	

B10-11-1

(47)

102201

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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DART AEROSPACE LTD	Work Order:	63326
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.98	+/-0.030	.980	✓		V HBOL	
1.00	+/-0.030	.996	✓		V	
Ø0.257	+0.005/-0.000	.261	✓		V	
3.36	+/-0.030	3.363	✓		V	
2.48	+/-0.030	2.482	✓		V	
0.555	+/-0.010	.555	✓		V	

Measured by:	RB
Date:	10-11-1

Audited by:	
Date:	10/4/01

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue	KJ/RF	
B	04.06.15	Removed 0.250 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	

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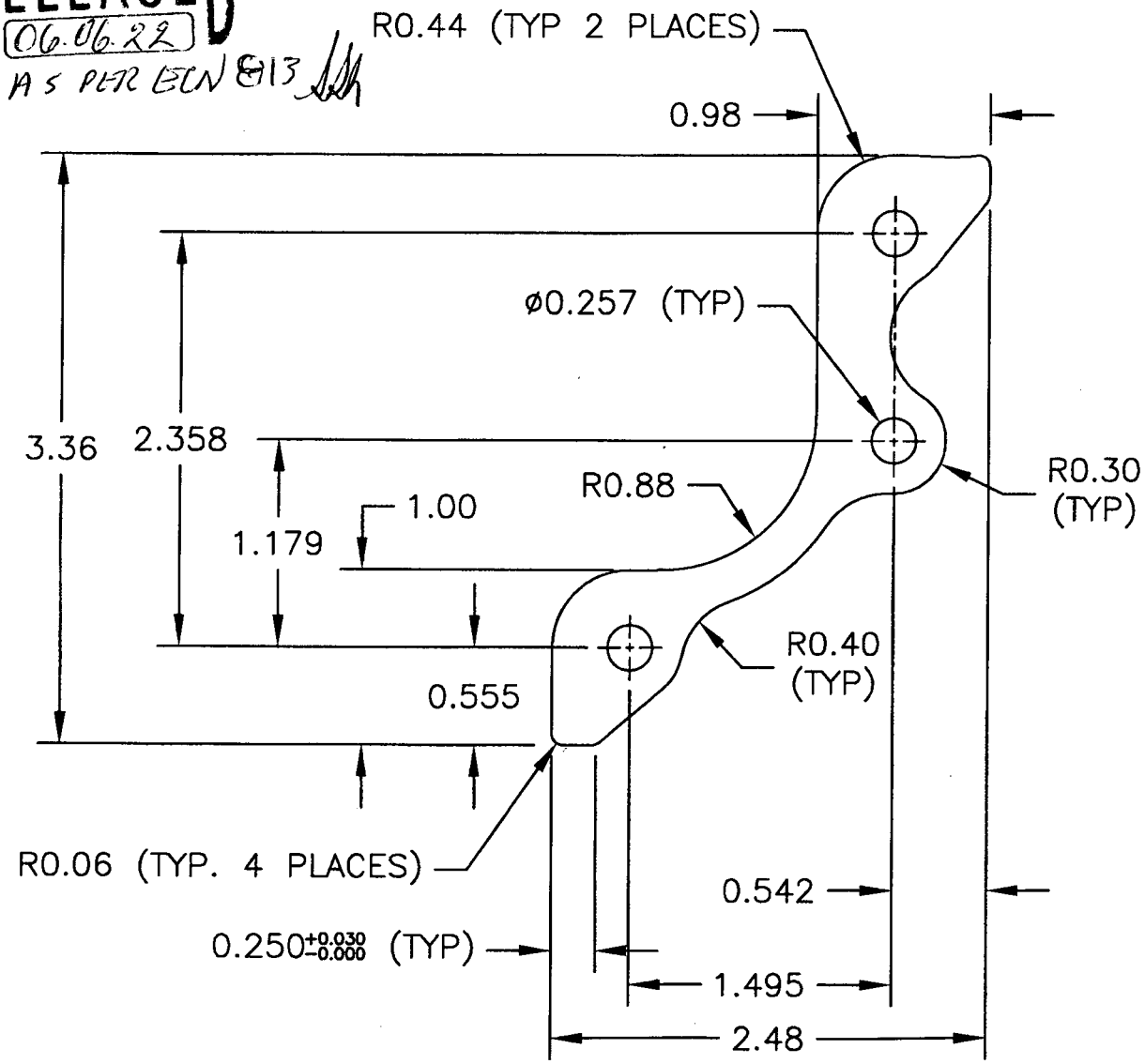
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1

A	99.02.23	NEW ISSUE
B	06.06.02	MATERIAL CHANGE

RELEASED
06.06.22
AS PER ECN 813



NOTES:

1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.010 TO 0.020
5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43326

10-10-27

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